

Date: Thursday, 12/14/2006 3:46:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001, Dart Helicopters Services		Drawing Name	: 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION		
Job Number	: 29985					
Estimate Number	: 10306					
P.O. Number	: N/A		Part Number	: D26005108		
This Issue	: 12/14/2006 S.O. No. : N/A		Drawing Number	: D2600 REV D1		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D1		
Previous Run	: 24410		Material	: N/A		
Written By			Due Date	: 1/15/2007 Qty: 115 Um: Each		
Checked & Approved By						
Comment	: Est F 02.99.10 Added DSK 066 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: Issue P/O: 2722	<p>a) Extrude as per Dwg D2600</p> <p>b) Material: 6061-T6 (QQ-A-200/8)</p> <p>c) Minimum yield tensile strength = 35 ksi</p> <p>d) Minimum ultimate tensile strength = 40 ksi</p> <p>e) Minimum elongation = 8%</p> <p>f) Order at 108" long</p> <p>g) Caradon Indalex Tool # MS-18871</p> <p>h) To be packed per DSK 066</p> <p>i) Pull test to ASTM standard B221 required.</p> <p>j) Material certification is required</p>
2.0	D26005108P	Extrusion 'I' Beam' thin
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 115.0000 Each(s) EXTRUSION "I" BEAM THIN	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: Receive & Inspect For Transit Damage Ensure certification is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK 1-Inspect dimensions per Dwg D2600 2-Check Pull test per Dwg D2600 for compliance page attached. 3-Check hardness with Webster tester	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION

Job Number: 29985

Part Number: D26005108

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

in the shop

JD 7-3-1

280

6.0 QC21

FINAL INSPECTION/W/O RELEASE



280

Comment: FINAL INSPECTION/W/O RELEASE

JD 07/03/05

Job Completion



CL 8/03/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS	+GP

RELEASED
 48.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

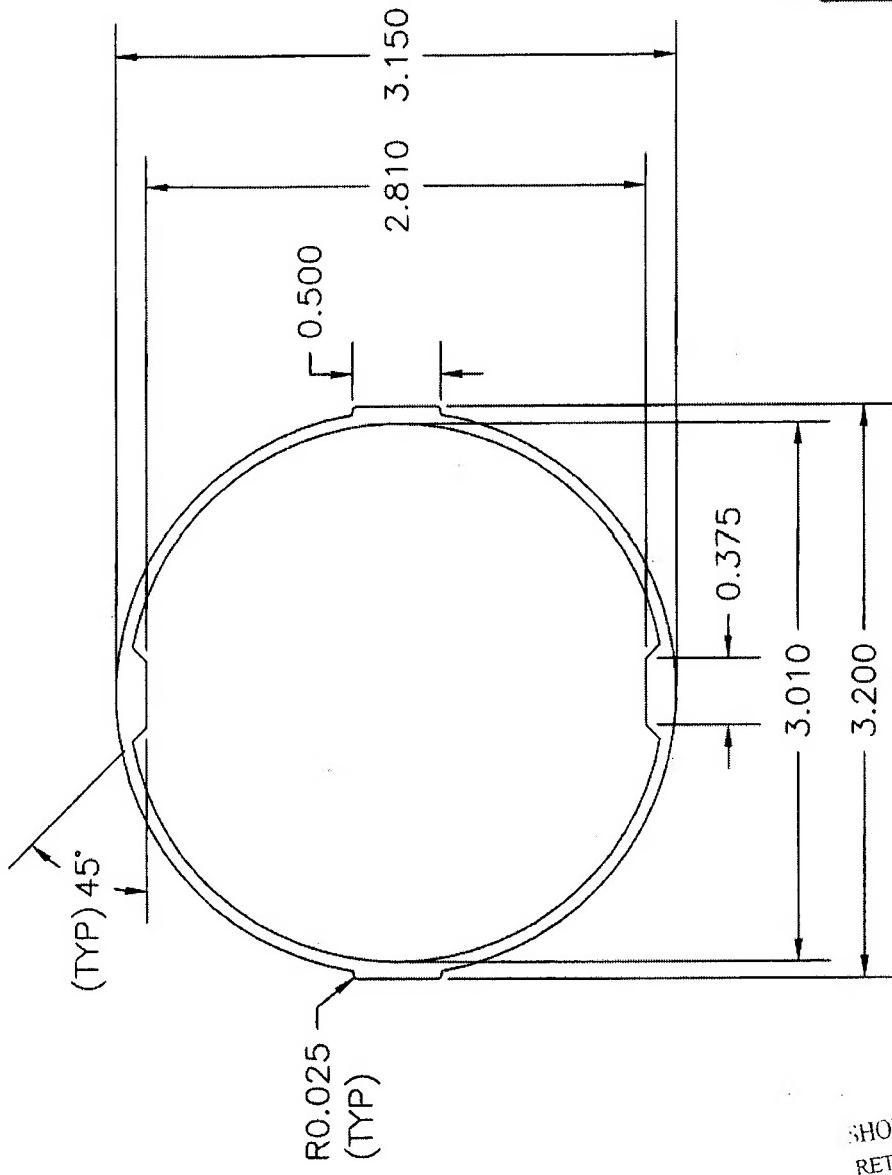
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DSD2600-1

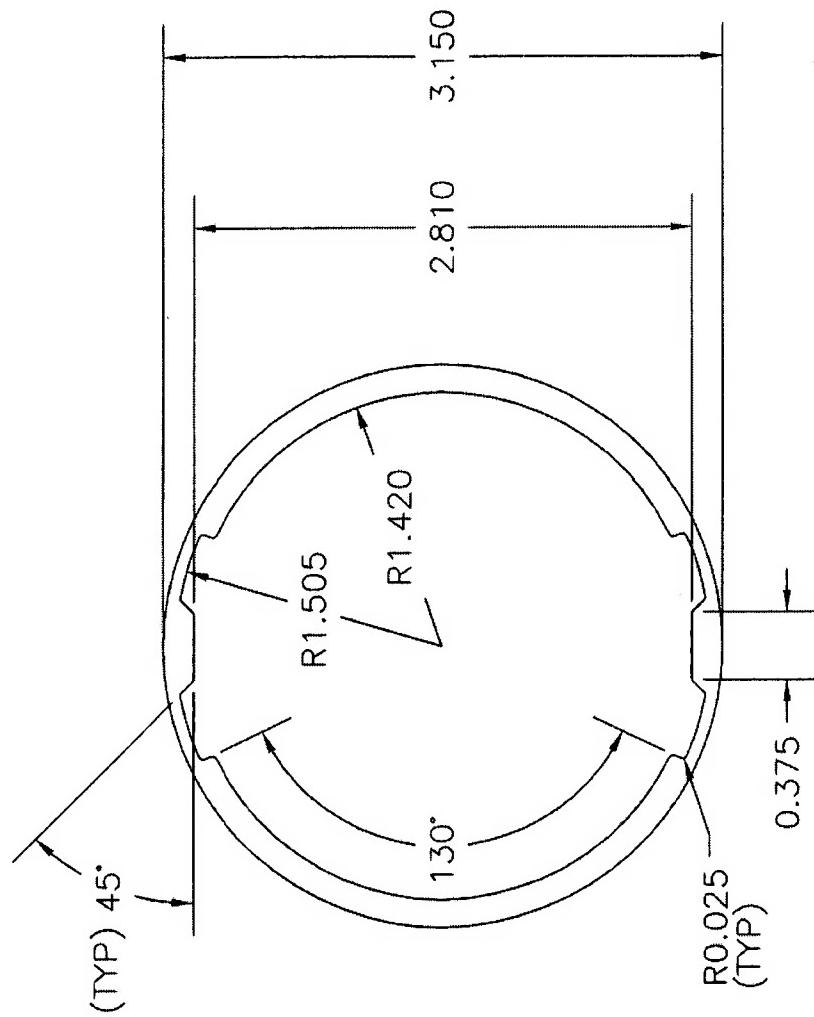
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MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
or Bon L Die # 877121 (PREFERRED CHOICE)
PART Number is D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 VS 160" Long)



DARTA COPY IS
MADE

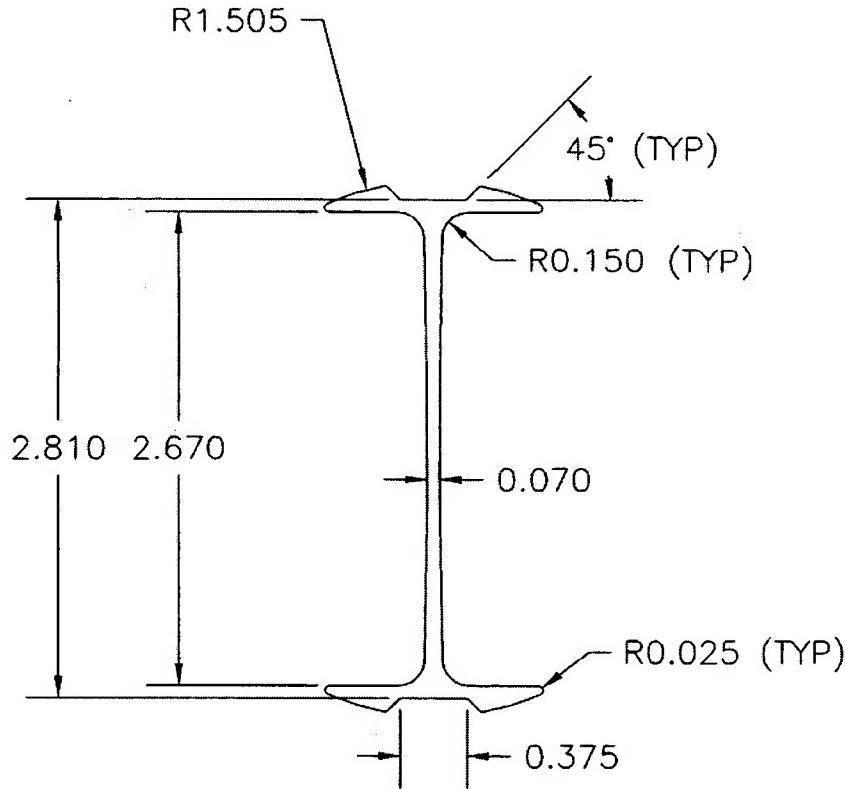
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DATE		TITLE EXTRUSION SCALE 1:1

D2600-3

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MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" long)



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

△ D1
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98 8.25. DS

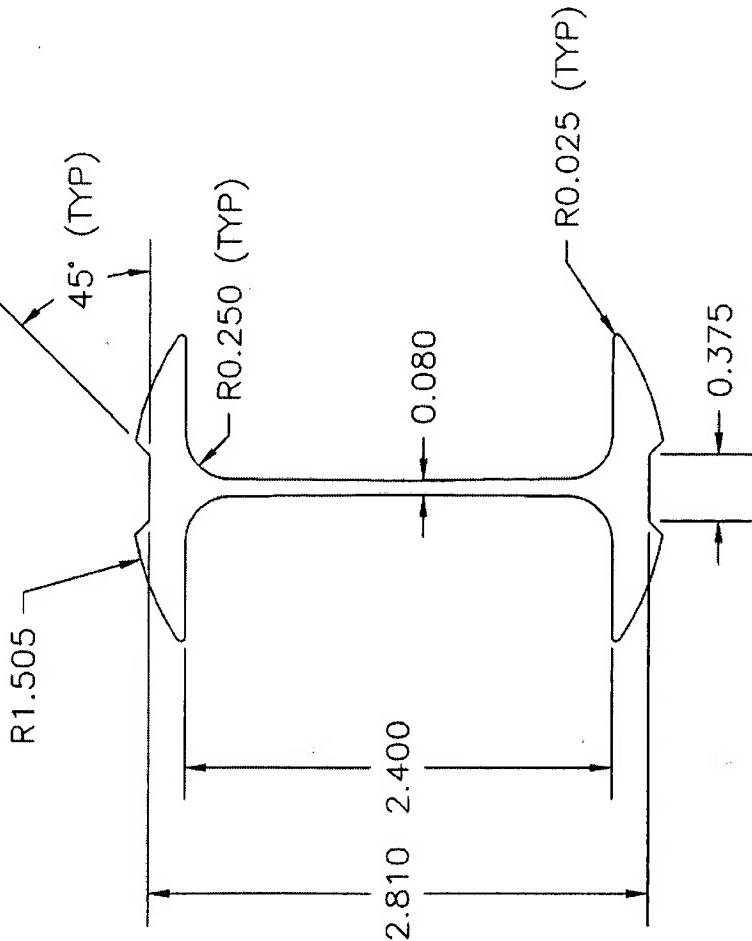
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DESIGN	DRAWN BY	DART AEROSPACE LTD
98	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	98.08.20	D2600
		TITLE
		EXTRUSION
		SHEET 4 OF 5
		SCALE
		1:1

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DESIGN <i>MR</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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WORK ORDER
NO. *29985*





325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 6122003

bon de commande / Purchase order # : 2722

de matrice / Die #: MS 18871 Description : D-2600-5 Light Duty Web

Alliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 36071-1

Coulée / Cast # : 39544

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	47659
Contrainte élastique Yield stress (psi)	35 000	43224
% élongation dans 2" % elongation in 2"	8 -	12.5
Dureté Rockwell E (hrc) Rockwell E Hardness (hrc)	88 @ 100	56

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	B
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.09 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6361	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.60	0.40 - 0.60	-	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre.
Yours truly,

date : 2007-01-08

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited



INDALEX LIMITED
325 AVRO Street
POINTE-CLAIRE, QC H9R 5W3

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young **FROM: Bruno Morency**
Quality Technician

COMPANY: DART AEROSPACE LTD **DATE:** 2007/01/08

PER NUMBER: **TOTAL NO. OF PAGES INCLUDING COVER:**
1(613) 632-4443 **2**

PHONE NUMBER: _____ **SENDER'S REFERENCE NUMBER:** _____

SUBJECT: **TIME:**
REPORT

URGENT FOR REVIEW PLEASE COMMENT PLEASE REPLY PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report

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